

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 65413

Monday, January 17, 2011 9:06:16 AM

Page 2

Item ID: D3651-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Aft Base Assembly
Start Date: 1/18/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 1/31/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>used onk w/b</i> <i>D3646-041 B65407</i>	0.00 0.00		<i>SB</i>		<i>(1)</i>			
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<i>OK</i>	<i>11/01/24</i>		<i>CMF</i> <i>11-01-21</i>

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Picklist Print

Monday, January 17, 2011 9:06:13 AM

Page 1

Work Order ID: 65413

Parent Item: D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 1/18/2011


Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C ecn1162 08-04-02 DD verified by: EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

CR3523-4-02		Purchased	No			100	Each	644.0000	58	58			
													
RIVET													

Location	Loc Qty	Loc Code
ST312	300	
115768	300	
ST313	344	
116022	44	
116391	200	
116471	100	

58 11/01/20


58

D3651-043		Manufactured	No			110	Each	5.0000	1	1			
													
Flange Weldment													

Location	Loc Qty	Loc Code
ST189	5	
45830	1	
61746	4	

1 11/01/20

21

D3651-1		Manufactured	No			110	Each	12.0000	1	1			
													
Gasket													

Location	Loc Qty	Loc Code
ST188	12	
45831	4	
61748	8	

1 11/01/20

21

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Monday, January 17, 2011 9:06:13 AM

Page 2

Work Order ID: 65413

Parent Item: D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 1/18/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3651-11

 Gasket

Manufactured No

110 Each 3.0000

1 1



SB 11/01/20 ①

Location

Loc Qty

Loc Code

GA

3 B65162

44675

1

45452

2

D3651-13

 Outside Doubler

Manufactured No

110 Each 5.0000

1 1



SB 11/01/20 ①

Location

Loc Qty

Loc Code

GA

1

44676

1

ST188

4

62493

4

D3651-9

 Inside Doubler

Manufactured No

110 Each 6.0000

1 1



SB 11/01/20 ①

Location

Loc Qty

Loc Code

ST188

6

45451

2

62814

4

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

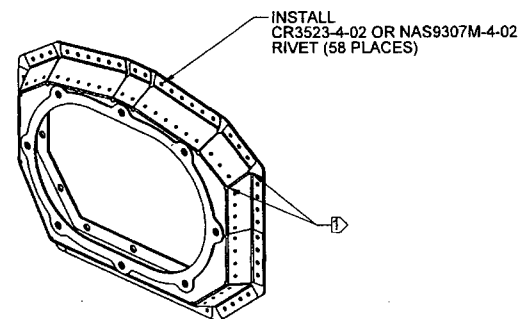
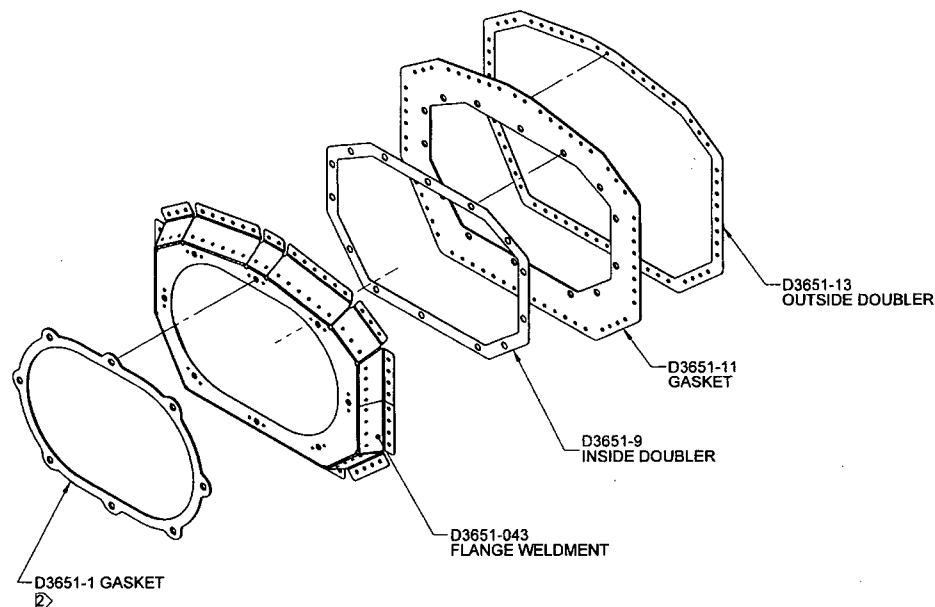
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



#65413

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

RELEASED
08-03-27/ND

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 9.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	08.01.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3651** REV. B
TITLE **AFT BASE ASSEMBLY** SCALE 1:4

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8 7 6 5 4 3 2 1

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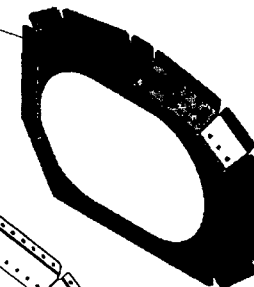
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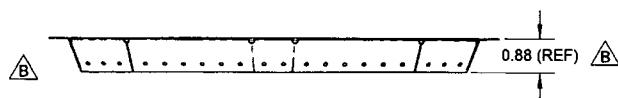
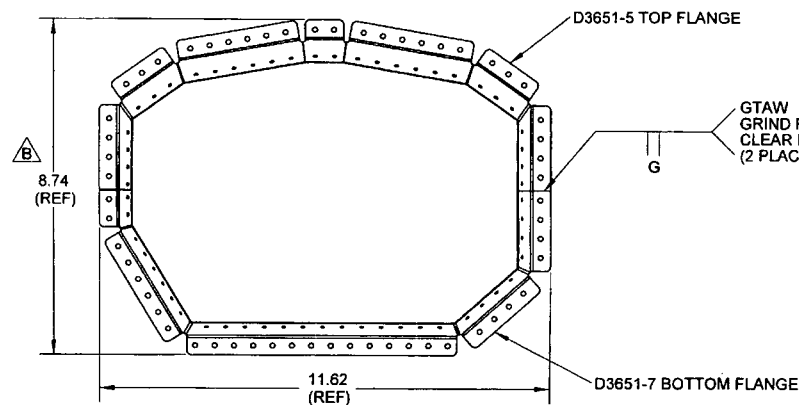
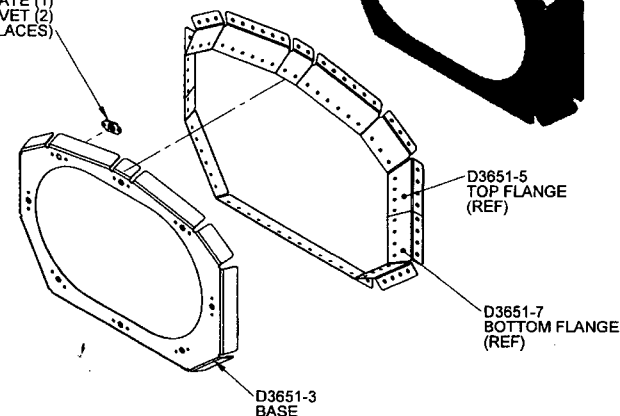
NOTE: Date & initial all entries

TRANSFER DRILL $\phi 0.129$ (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)



MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

GTAW
GRIND FLAT TO
CLEAR FASTENERS
(2 PLACES)



D3651-043 FLANGE WELDMENT

D3651-043 NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.76 lbs

#65413

QTY	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

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08-03-27-14

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MFG. APPR.	MA	D3651	SHEET 2 OF 9
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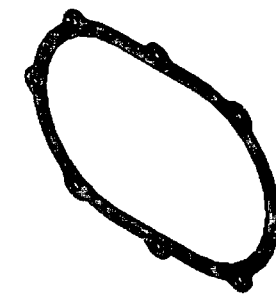
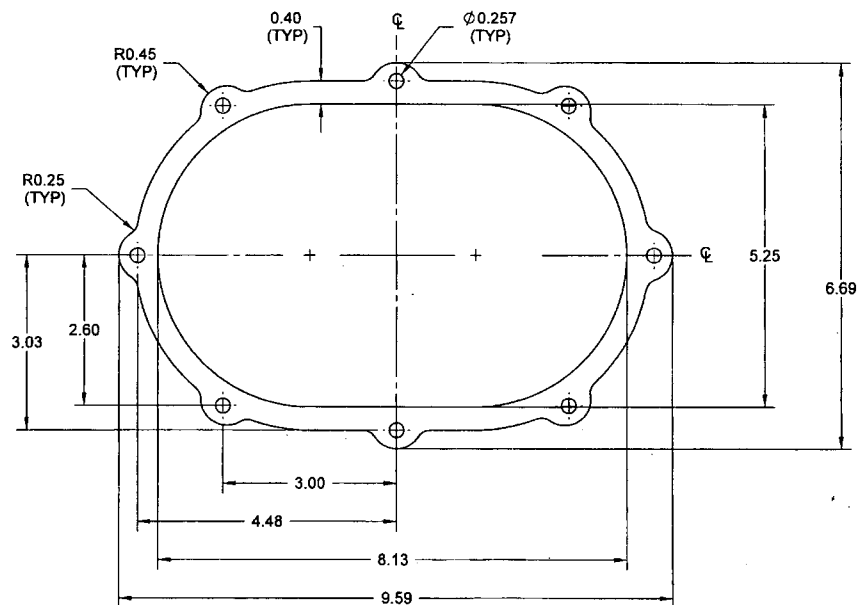
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NOTE: Date & initial all entries



#65413

D3651-1 GASKET

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

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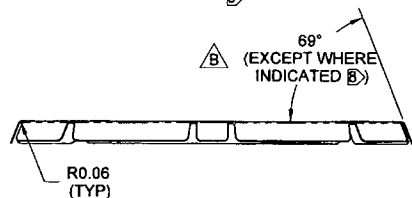
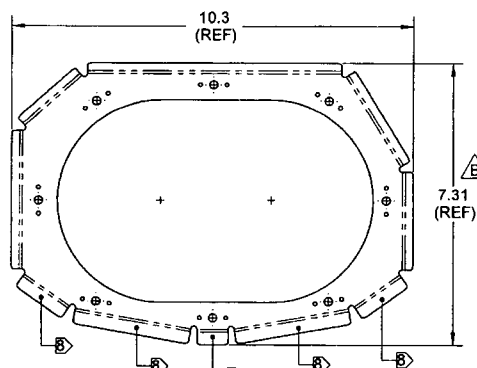
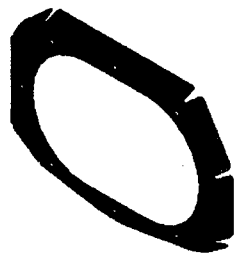
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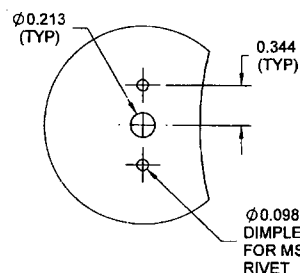
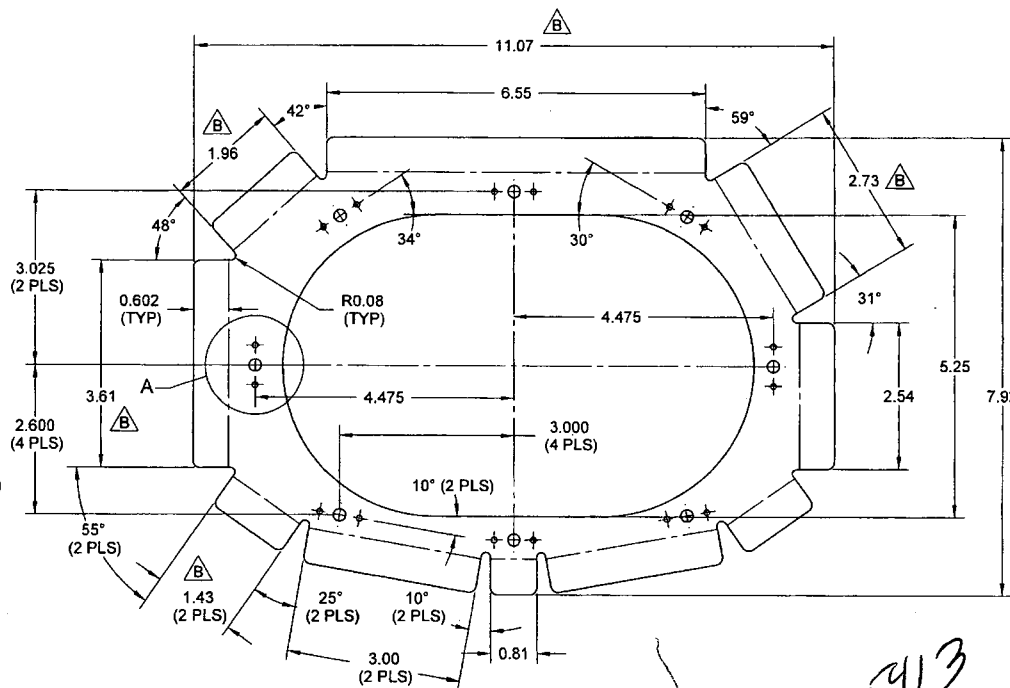
NOTE: Date & initial all entries



D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED



DETAIL A

D3651-3F FLAT PATTERN

#05913

08-03-27-14

DESIGN	RF	DART AEROSPACE LTD	
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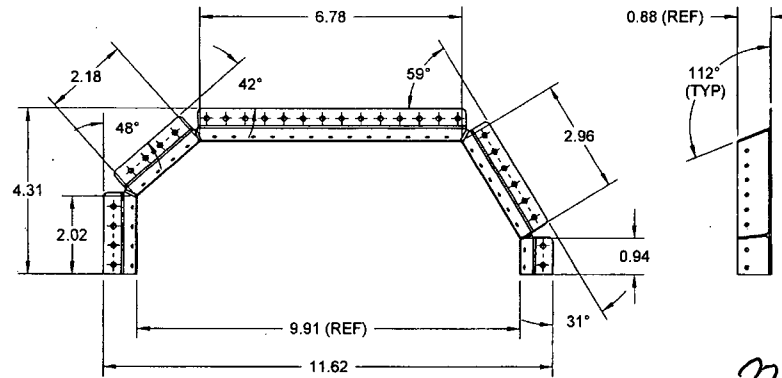
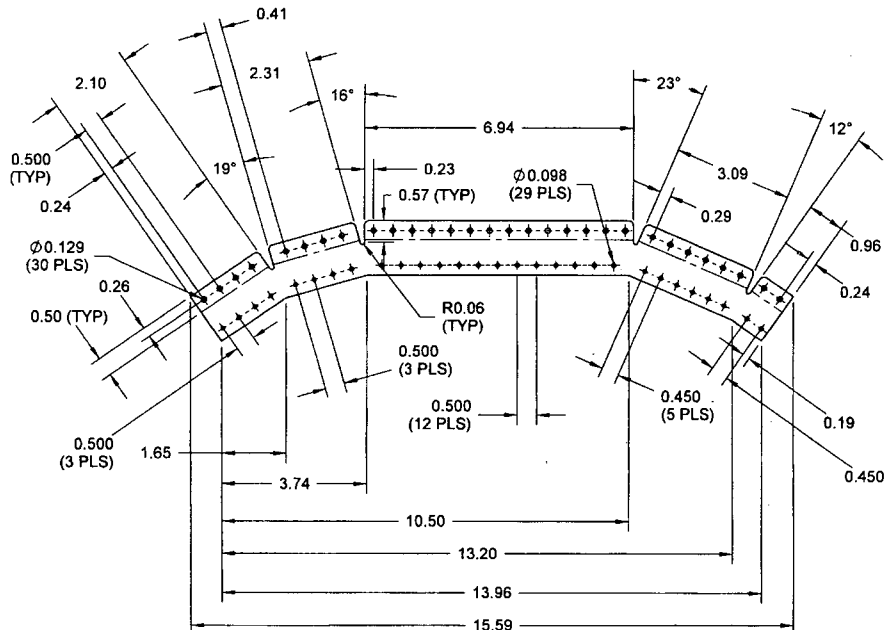
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

#65413

D3651-7F FLAT PATTERN B

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

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MFG. APPR.	MP	D3651	SHEET 6 OF 9
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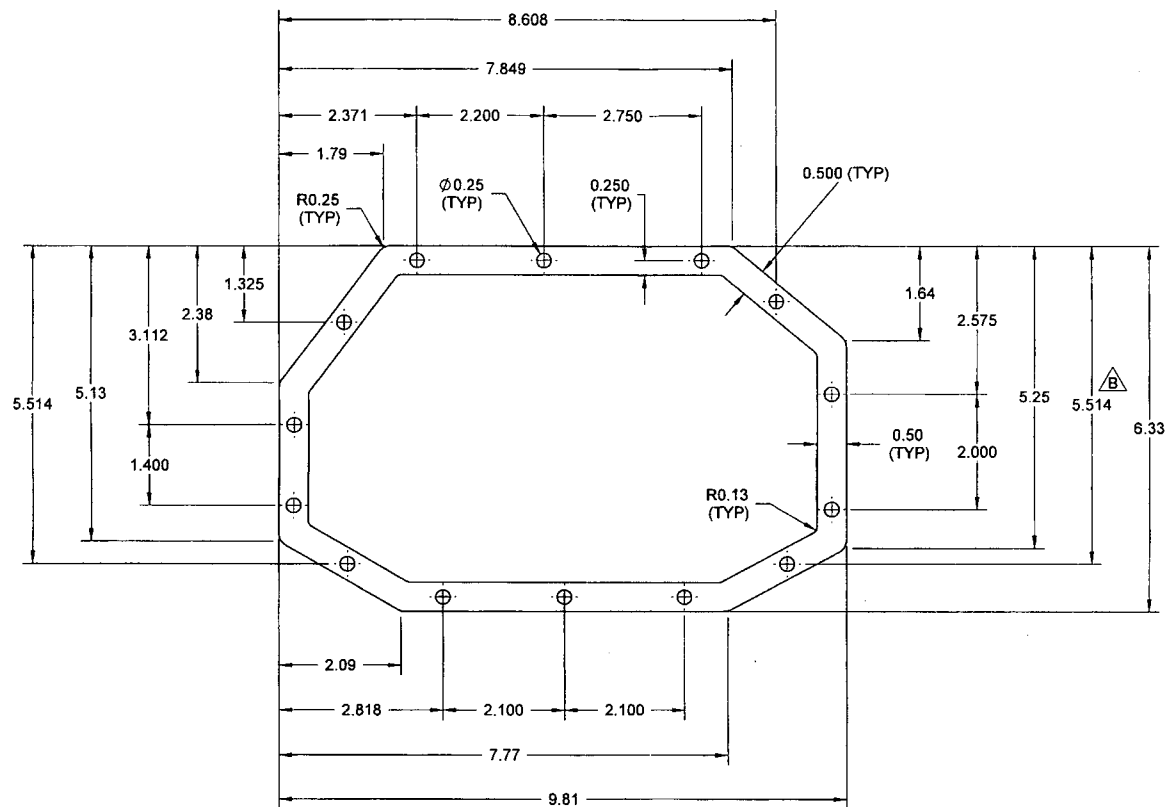
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D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

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MFG. APPR.	WLE	D3651	SHEET 7 OF 9
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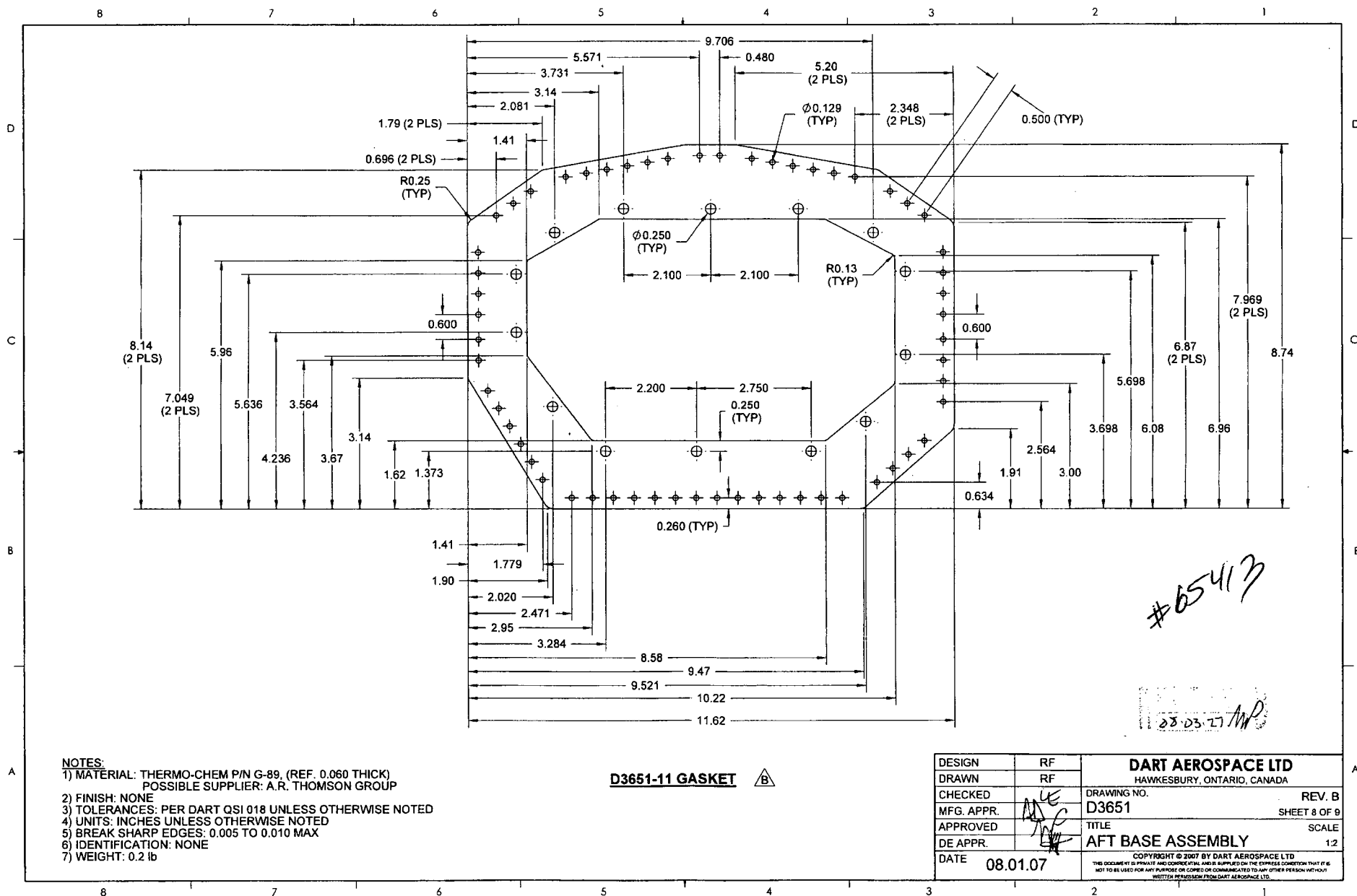
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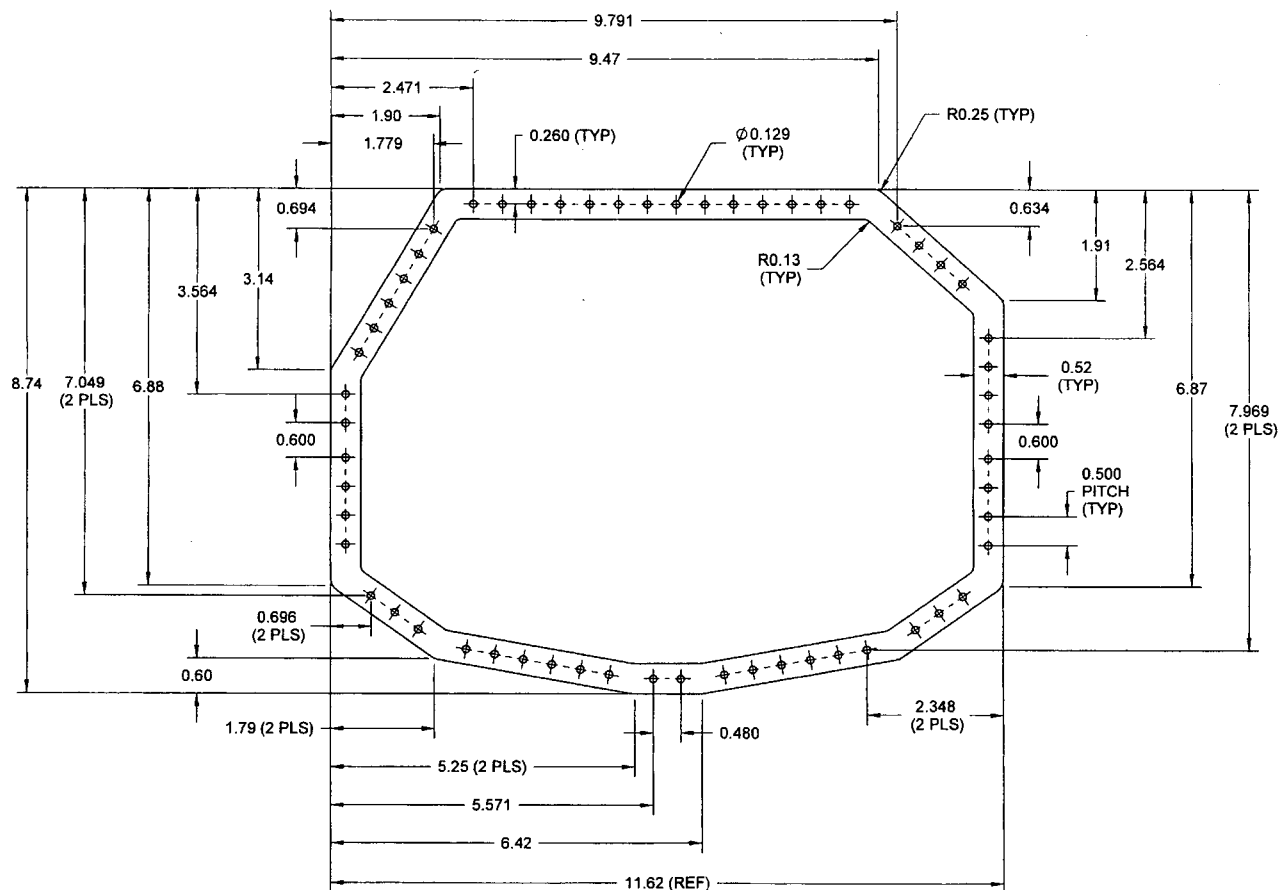
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


NOTE: Date & initial all entries



D3651-13 OUTSIDE DOUBLER 

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		SHEET 9 OF 9	
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:2
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#65413

08-03-27/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries